

# Work Order ID 68650

Tuesday, April 19, 2011 1:47:08 PM



Page 1

Item ID:	D4311-3	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Rappel Placard					
Start Date:	4/19/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	4/20/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>11/04/19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4311	<u>PA3 PA5 A</u>

100		0.00							
Purchasing		0.00							<u>CZ 11/04/19 (2)</u>

Purchasing	Memo								
	Issue P/O: <u>13909</u>								
	Manufacture as per Dwg D4311								
	Possible Supplier: Studio Lettrage								
	Material release note required								

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging		0.00							<u>11/4/20 (2)</u>

Packaging	Memo								
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120	QC6- Inspect dimensions to drawing	0.00							
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QC		0.00							

Quality Control									
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- inspector to PA5

Due only  
8/11/20 (2)

**PRELIMINARY ISSUE**

PA5

**Work Order ID 68650**

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Item ID: D4311-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Rappel Placard

Start Date: 4/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

ship to Eagle

CL 11/04/20 X2

Packaging

ATTN: Harvey

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10 [Signature]

CL 11/04/20

POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

DATE

4/19/11  
4/19/11  
4/19/11

# Picklist Print

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Work Order ID: 68650



Parent Item: D4311-3



Parent Item Name: Rappel Placard



Start Date: 4/19/2011

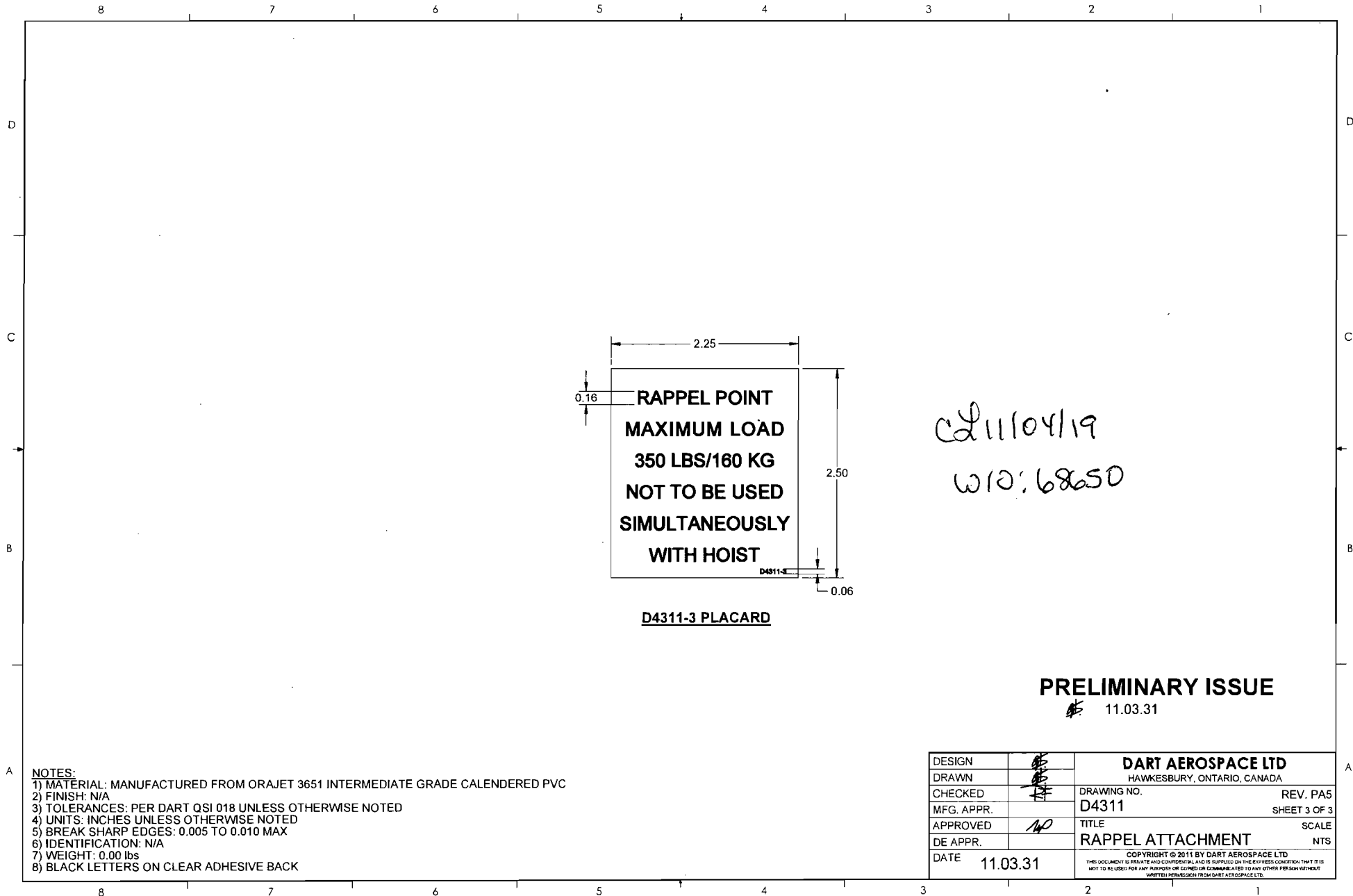
Required Date: 4/20/2011

Start Qty: 2.00





Required Qty: 2.00

Comments: IPP revA 11.01.04 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4311-3P  Rappel Placard		Purchased	No				Each	0.0000		2		4/4/20 @	



NOTES:  
1) MATERIAL: MANUFACTURED FROM ORAJET 3651 INTERMEDIATE GRADE CALENDERED PVC  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.00 lbs  
8) BLACK LETTERS ON CLEAR ADHESIVE BACK

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4311	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RAPPEL ATTACHMENT	NTS
DATE	11.03.31	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO13909**

Purchase Order Date 4/19/2011

PO Print Date 4/19/2011

Page Number 1 of 1

**Order From :**

VC-STU001

STUDIO DE LETTRAGE 2001  
210 MAIN WEST  
HAWKESBURY, ON K6A 2H6  
CA

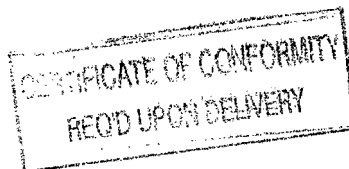
Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 632 5449	Requisition Nbr	
Vendor Fax	613 632 9491	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4311-3P	Rappel Placard	4/20/2011 Yes	2.00 Each	Yours ppa	\$37.5000	\$75.00

Special Inst: AS PER DWG D4311 REV.  
B68650  
MATERIAL: ORAJET 3651  
INTERMEDIATE GRADE CALENDERED  
PVC

PO Total: \$75.00



Change Nbr: 1

Change Date: 4/19/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

210 Main Street W  
Hawkesbury, Ontario K6A 2H6

Invoice No.: 15582  
Date: 04/20/2011  
Ship Date:  
Page: 1  
Re: Order No. 10680

**Dart Aerospace Ltd**  
1270 Aberdeen  
Hawkesbury, Ontario  
K6A 1K7

Dart Aerospace Ltd  
Hawkesbury, Ontario

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		2	D4311-3P set up	H	25.00	50.00
		1	printing	H	25.00	25.00
			H - HST 13%			
			HST			9.75
			PST Exempt: #6122-5207			
<div style="text-align: center; font-size: 2em; font-family: cursive;">             8/14/20           </div>						
Studio de Lettrage HST: #869034678RP001 Shipped By:                      Tracking Number:						
Comment: PO 13909						
Sold By:						
<b>Total Amount</b>						<b>84.75</b>



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## ORAJET 3651 Intermediate Grade Calendered PVC Inkjet Media

### Description

5-year calendered PVC film available in transparent or in white with a gloss, semi-gloss, or matte surface.

### Release Liner

90# PE-coated silicone paper

### Adhesive

Grey, solvent-based, permanent

### Areas of Use

General signage, vehicle graphics and other medium-term applications

### Printing Techniques

Solvent inkjet

### Thickness

(without paper and adhesive) 2.5 mil

### Dimensional Stability

(FINAT TM-14) adhered to steel, no shrinkage in cross-direction; in length <.016"

### Temperature Resistance

Adhered to aluminum -40°F to +176°F no variation

### Adhesive Power

(FINAT-TM 1, after 24 h) adhered to stainless steel: 4.1 lb/in

### Outdoor Durability

(based on vertical surface exposure) 5 years (unprinted)

### Shelf Life

2 years

### Seawaterability

Adhered to aluminum, after 100 hours/73°F, no variation

### Elongation at break (across)

150%

### Elongation at break (along)

130%

**Tensile Strength (across)**

Min 19 MPa

**Tensile Strength (along)**

Min 19MPa

**Flammability**

Adhered to steel, self-extinguishing

**Front Material**

Special PVC film with surface treatment, 2.5 mil.

**Minimum application temperature**

46 °F

**Available Widths (in inches)**

30, 36, 50, 54, 60

**Available Lengths**

50 yards

**Surface finish**

Gloss, Matte, Semi-gloss

**Number of Colors**

White, Transparent

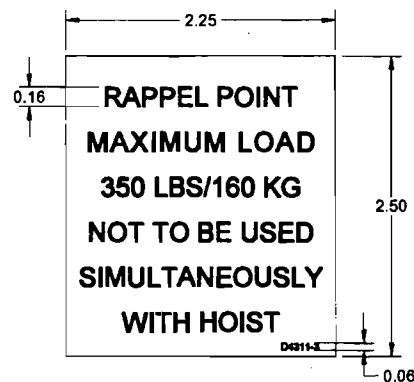
**Hardware**

Colorspan DisplayMaker 72s; Encad Vinyl Jet 36; DGI VT-11, VT-100D; Mimaki JV3 SP; Mutoh Albatros, Toucan, Outdoor, Outdoor II, Oce Arizona; Nur Fresco, Salsa, Blueboard; Roland Sol Jet II EX, VersaCamm SP-300; Scitex Idanit Novo, Grandjet, PressJet; VUTEK Press Vu, Utra Vu

**Recommended Printing Inks**

UV-resistant solvent dyes for outdoor application





**D4311-3 PLACARD**

68650

**RELEASED**  
2011-05-10

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DRAWN	<i>DE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DE</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>DE</i>	<b>D4311</b>	SHEET 3 OF 4
APPROVED	<i>DE</i>	TITLE	SCALE
DE APPR.	<i>DE</i>	<b>RAPPEL ATTACHMENT</b>	NTS
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